

Date: Thursday, 3/16/2006 10:37:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 26264	
Estimate Number : 12183	
P.O. Number : N/A	Part Number : D3469043
This Issue : 3/16/2006 S.O. No. : N/A	Drawing Number : D3469 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 3/31/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.16</u>	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34691	TUBE
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3469-1	Tube	
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*Fabricate by hand
as per dwg D3469*

*M19704 (M30450A26GA)
(12" x 10") x 2*

03062801

2.0	D34693	UPPER PLATE BENDING DETAIL
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3469-3	Plate	<i>26113-1</i>
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03062801

3.0	AN960C416L
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	AN960C416L	Washer	
---	------------	--------	--

19336

03062801

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469 Using Dt8849 Assembly Jig, Use 1/4" Shaft To Align Butterfly Shaft holes

2-Spot Weld as per Dwg D3469 and Dart QSI 018

03062801

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PP Date: 02/03/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:37:28 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 26264

Part Number: D3469043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/9

WELD INSPECTION



060720
①



Comment: WELD INSPECTION

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg D3475

Ensure Certificate of Conformity is attached

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & inspect for Transit Damage

Ensure Material Release Note is attached

8.0

QC3

INSPECT-POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06 03 30 ①

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06 03 30 ①

Job Completion



06 03 30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

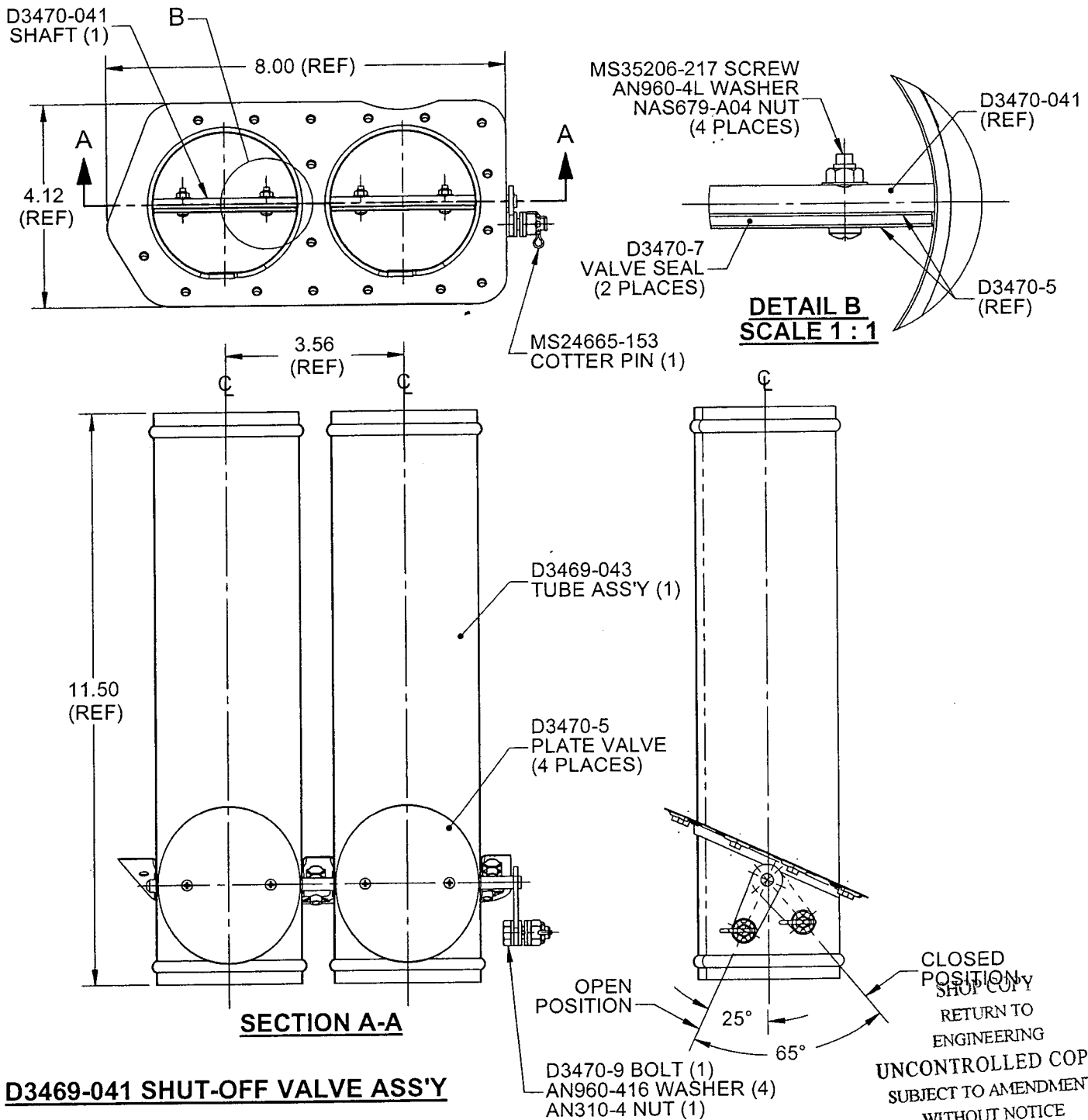
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	



D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

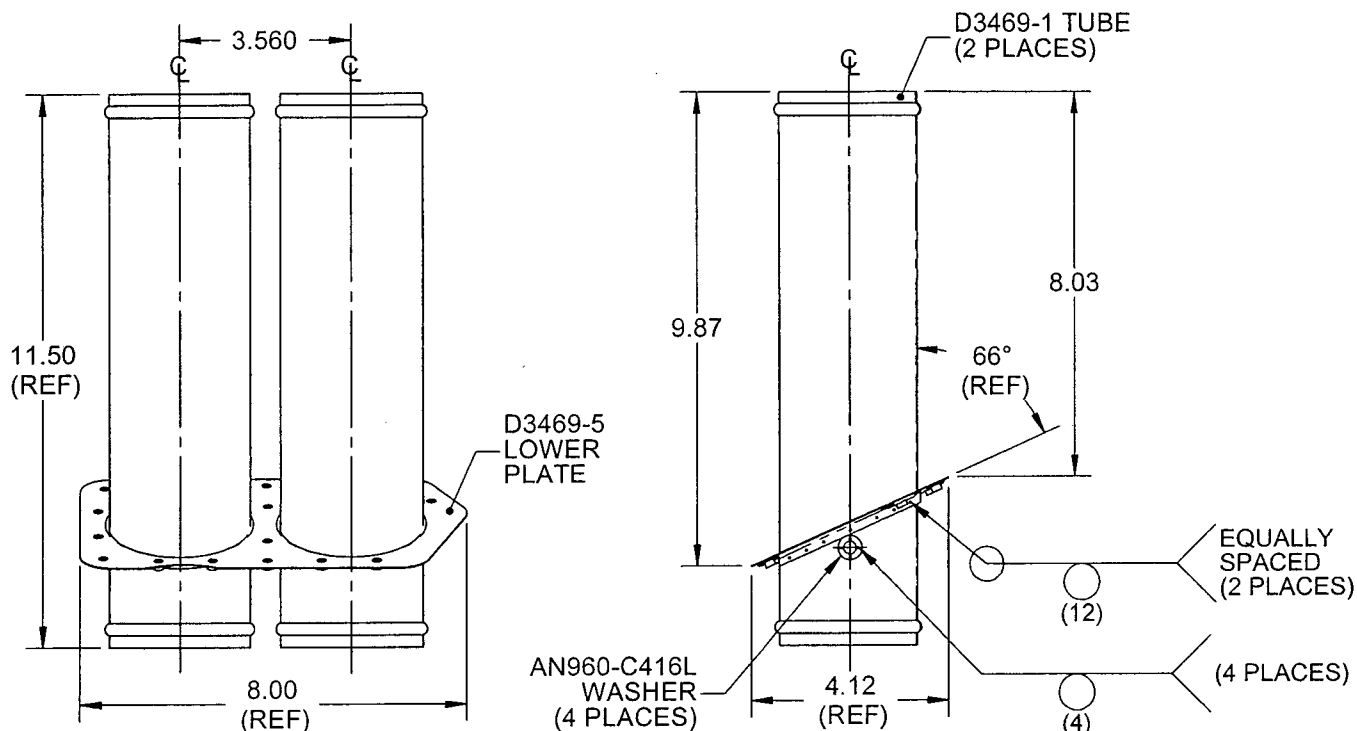
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO-CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

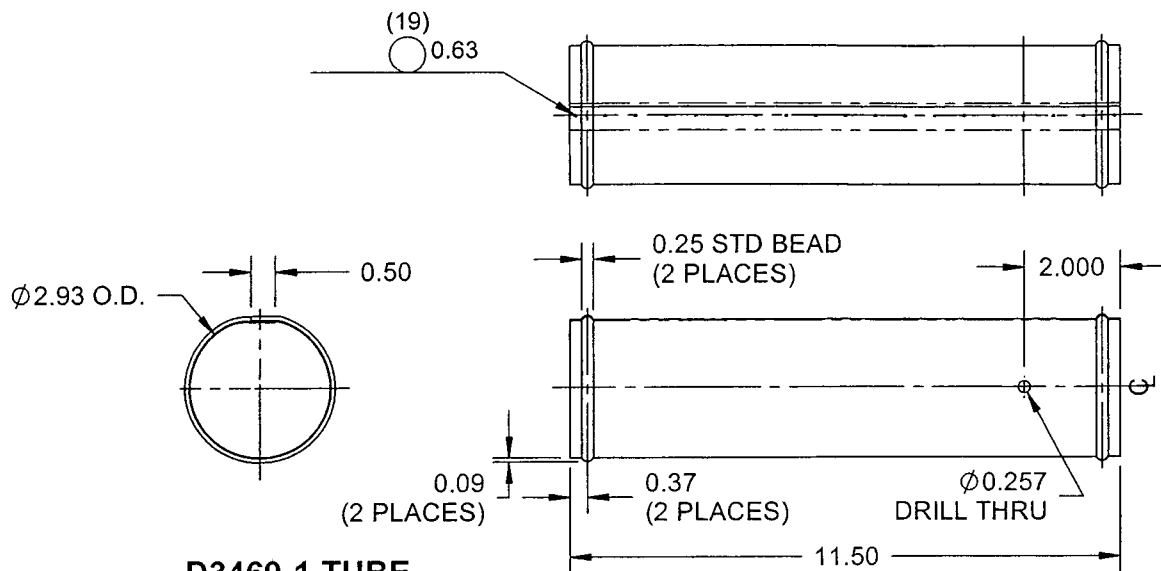
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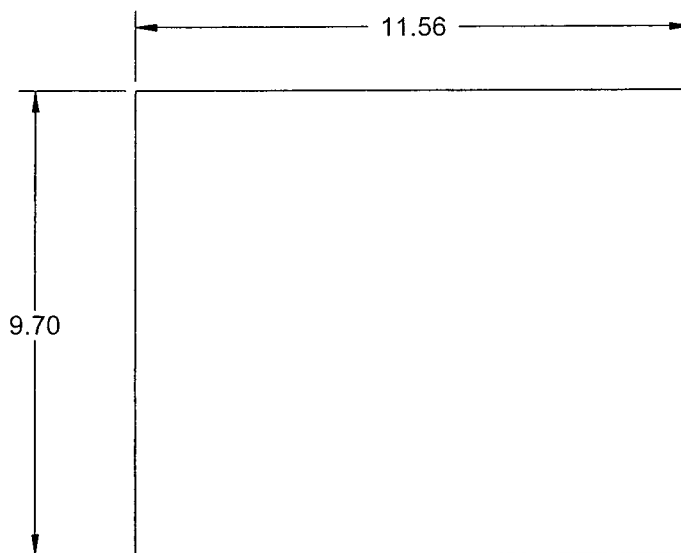
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DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:4



D3469-1 TUBE



D3469-1F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

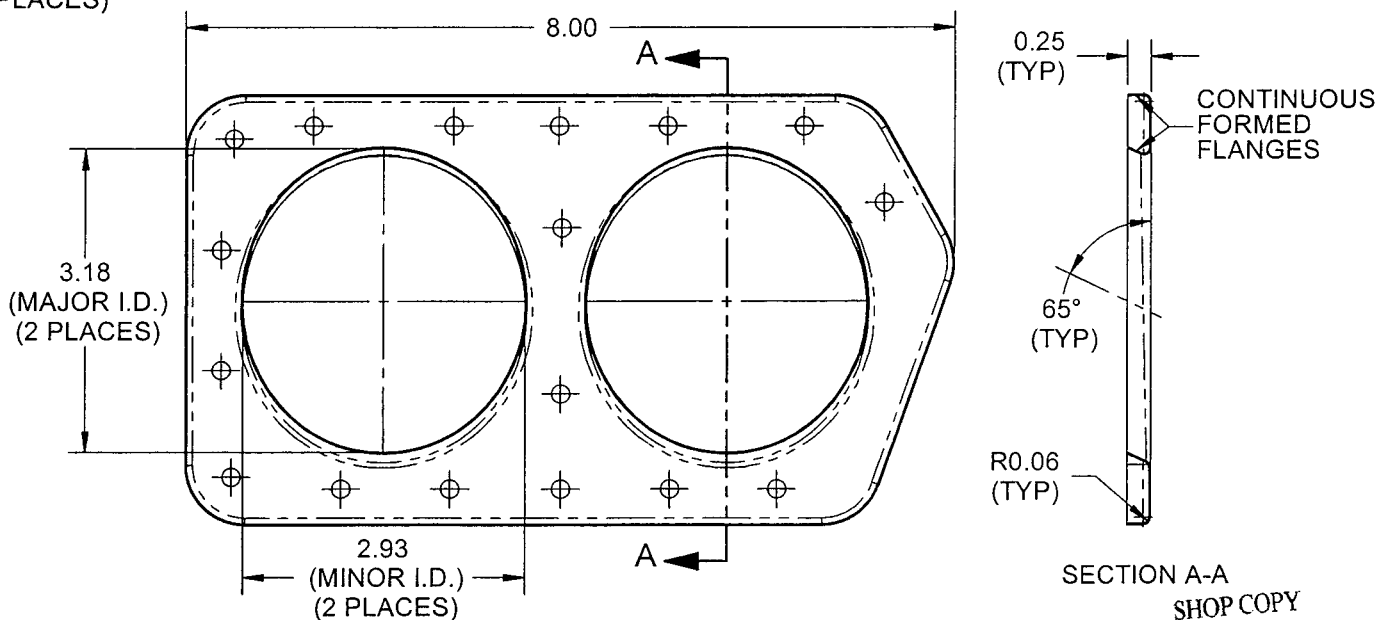
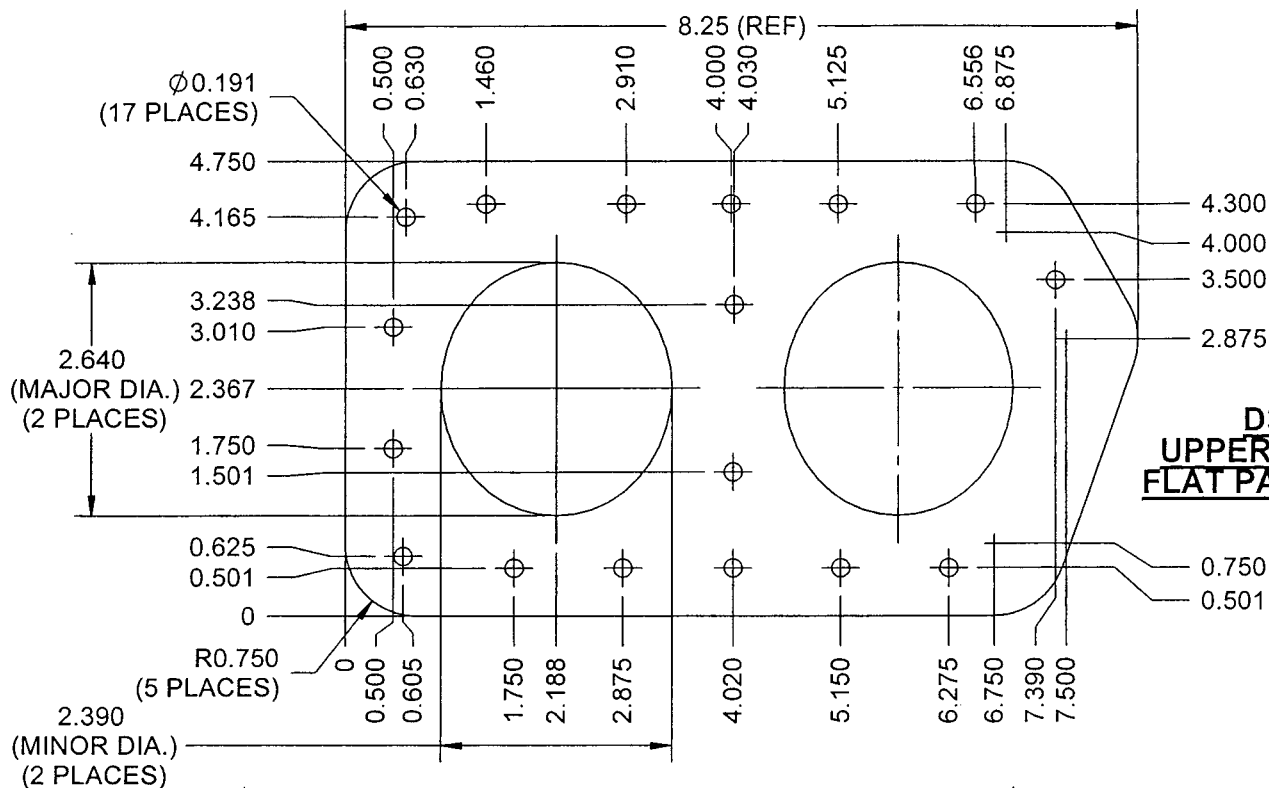
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO-CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

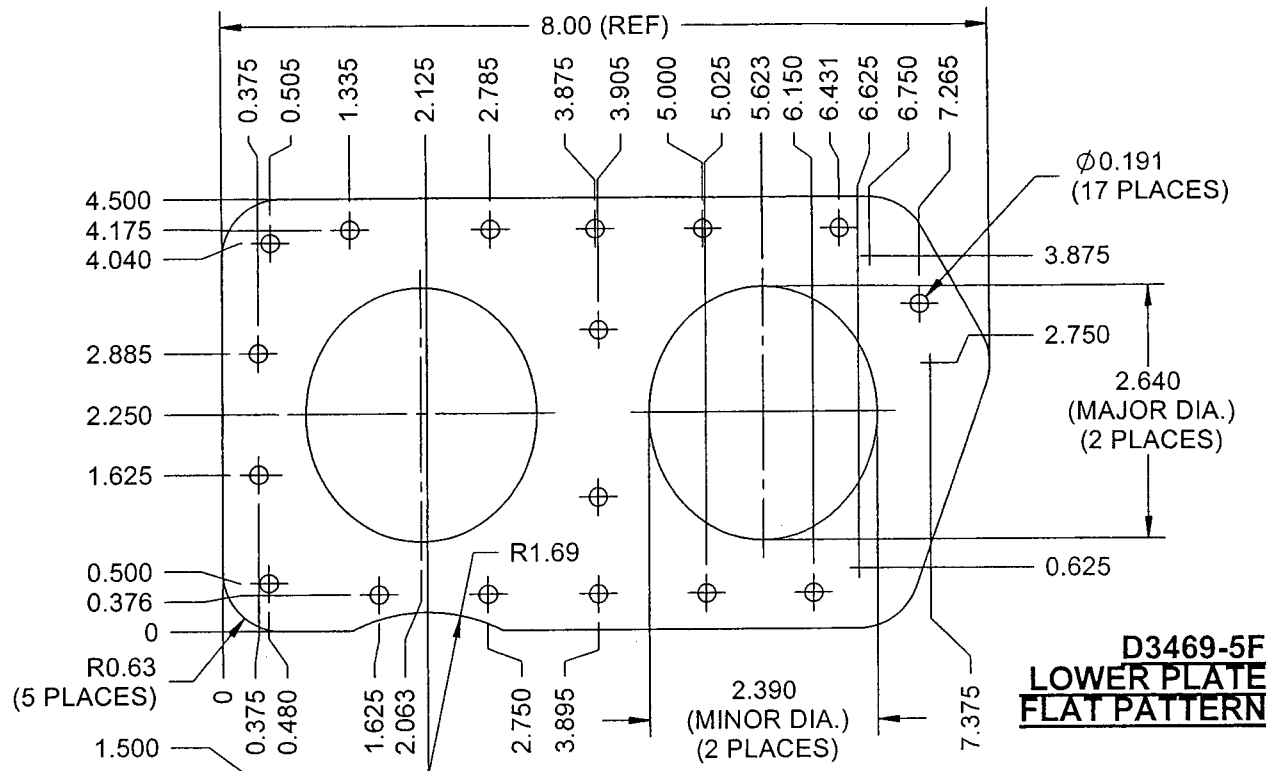
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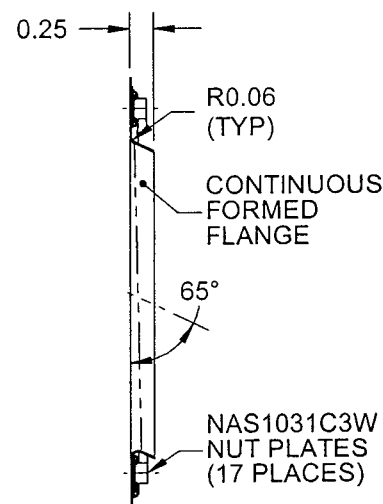
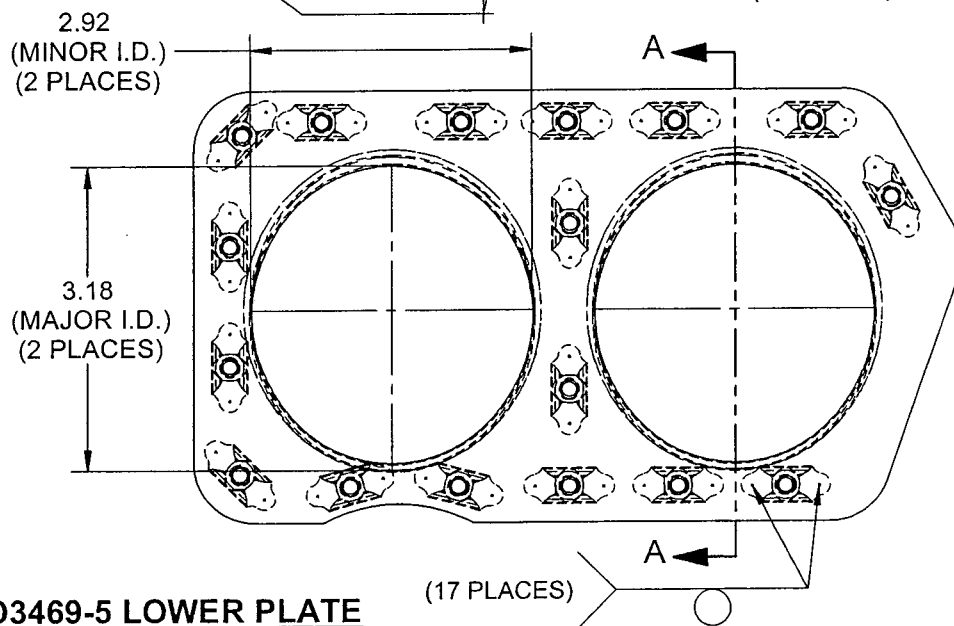
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DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:2



**D3469-5F
LOWER PLATE
FLAT PATTERN**



SECTION A-A

D3469-5 LOWER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: ELECTRO-CHEMICALLY POLISH
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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